

Work Order ID 76842

76842

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Tuesday, November 22, 2011 8:46:20 AM

Item ID: D3990-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cable Guard
 Start Date: 11/23/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/28/2011 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3990	A								

100 0.00

100

Waterjet

FLOW CNC Waterjet

Memo

Cut Blank as per File d3990-1-blank

0.00

11-23

3

110

0.00

110

HAAS 1

HAAS CNC vertical machine #1

Memo

Machine as per Folio FA345

Folio Rev: AA

Dwg Rev: B

Deburr as per Dwg

0.00

SC/BA

u.h.l.zu

3

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Work Order ID 76842

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Tuesday, November 22, 2011 8:46:20 AM

Item ID: D3990-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cable Guard

Start Date: 11/23/2011 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 11/28/2011 Req'd Qty: 1.00 *1* Customer:

Reference:

Sub 11-21

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	<i>SK/B.a</i>	<i>11/11/24</i>		<i>3</i>	<i>0</i>		
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	<i>RE</i>	<i>11-11-25</i>		<i>3</i>	<i>4</i>		
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <i>8703</i> Memo	0.00 0.00							<i>(3) Sp 11-11-25</i>

76842

Tuesday, November 22, 2011 8:46:20 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 11/23/2011 Start Qty: 1.00 *1*

Required Date: 11/28/2011 **Req'd Qty:** 1.00 ***1***

Reference:

Fun Start *NR1*

Approvals: _____ Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

Number Stamp
N 11/28 MF
11-11-25

Picklist Print

Tuesday, November 22, 2011 8:46:19 AM

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Work Order ID: 76842

Parent Item: D3990-1

Parent Item Name: Cable Guard

Start Date: 11/23/2011

Required Date: 11/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty/ on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHLWB1750X1000X 4800		Purchased	No			100	sf	0.0000	1.75	1.8421053		6.	
UHMW 1.75x1.00x48.00											11-11-23		

119145

③

DART AEROSPACE LTD		Work Order: 76842
Description: CABLE GUARD		Part Number: 3990-1
Inspection Dwg: 3990 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

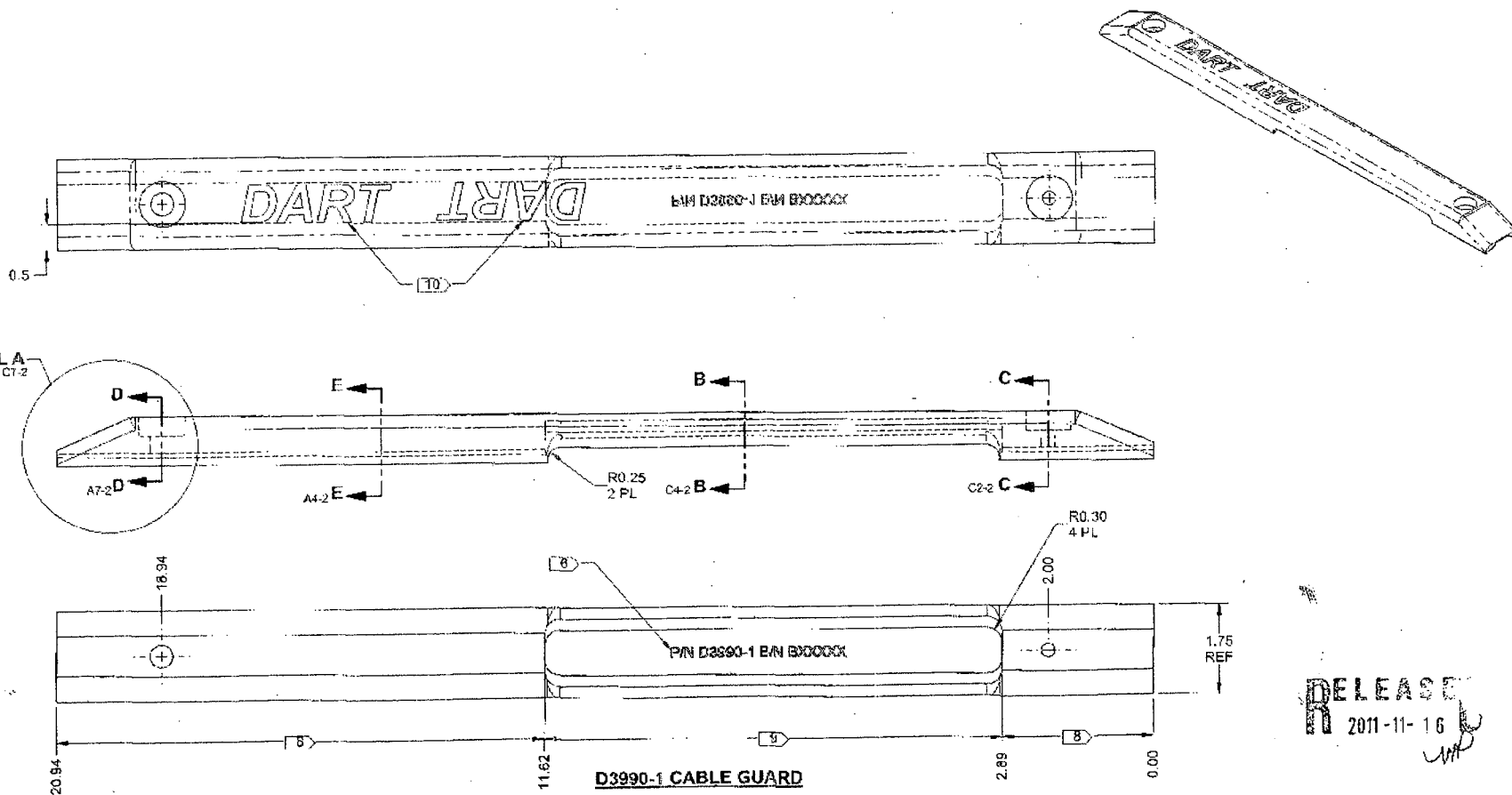
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
20.94	$\pm .03$	20.943	✓		SC 06	12" Vern
11.62	$\pm .03$	11.623	✓			
2.89	$\pm .03$	2.888	✓			
1.75	$\pm .03$	1.755	✓			
2.00	$\pm .03$	1.997	✓			
18.94	$\pm .03$	18.955	✓			
1.44	$\pm .03$	1.440	✓			
.64	$\pm .03$.640	✓			
.063	$\pm .01$.060	✓			
.65	$\pm .03$.640	✓			
R.50	$\pm .03$.50	✓			
1.31	$\pm .03$	1.320	✓			
.880	$\pm .03$.885	✓			
.10	$\pm .03$.110	✓			
.36	$\pm .03$.377	✓			
.14	$\pm .03$.157	✓			
.95	$\pm .03$.945	✓			
.70	$\pm .03$.711	✓			
R2.0	$\pm .03$	2.0	✓			
.78	$\pm .03$.790	✓			
Ø .261	$\begin{matrix} +.006 \\ -.001 \end{matrix}$.264	✓			
.37	$\pm .03$.370	✓			
Ø .875	$\begin{matrix} +.010 \\ -.001 \end{matrix}$.876	✓			

Measured by: TSC/B.K.	Audited by: RR	Preliminary Approval:
Date: 11/11/24	Date: 11-11-25	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DETAIL A
C7.2



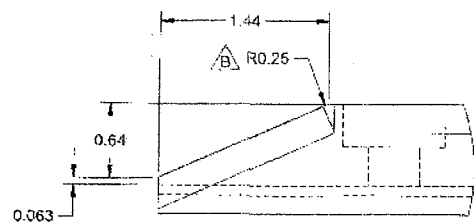
D3990-1 CABLE GUARD

NOTES:

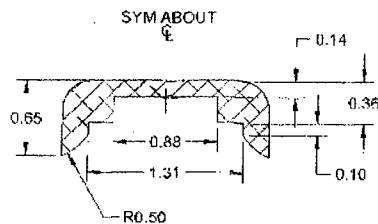
- 1) MATERIAL: MAKE FROM BLACK UHMW
REF DART SPECIFICATION MUHMB10
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE WITH DART P/N "D3990-1" AND B/N TO MAX DEPTH OF 0.015 AND MIN TOOL TIP RAD 0.25
- 7) WEIGHT: 0.64 lbs
- 8) MACHINE CONSTANT SECTION E-E, EXCEPT FOR DETAIL A
- 9) MACHINE CONSTANT SECTION B-B, EXCEPT FOR TRANSITIONS
- 10) ENGRAVE "DART" LOGO ON UPPER SIDE TO MAX DEPTH OF 0.015 AND MIN TOOL TIP RAD 0.25, 2 PL

B SEE SECTION E-E, ZONE B4-2 0.25 RAD ADDED.		AJS	11.11.10
A NEW ISSUE		IIS	09.08.28
REV.	DESCRIPTION	BY	DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	7/10	DRAWING NO.	REV. B
MFG. APPR.	4/1	D3990	SHEET 1 OF 2
APPROVED	7/10	TITLE	SCALE
DE APPR.	7/10	CABLE GUARD	NTS
DATE	11.11.10	COPYRIGHT © 2009 BY DART AEROSPACE LTD	

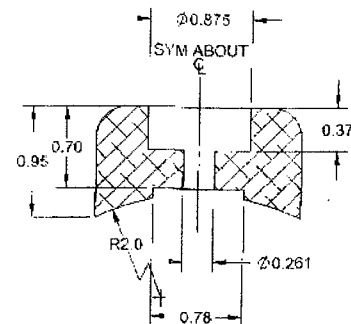
RELEASE
R 2011-11-16



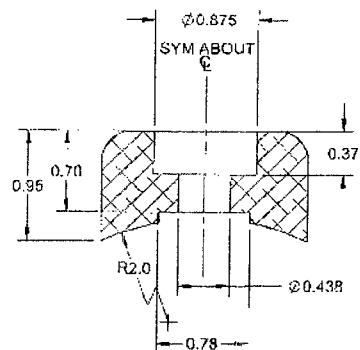
DETAIL A CR-1
SCALE 2X
(BOTH ENDS)



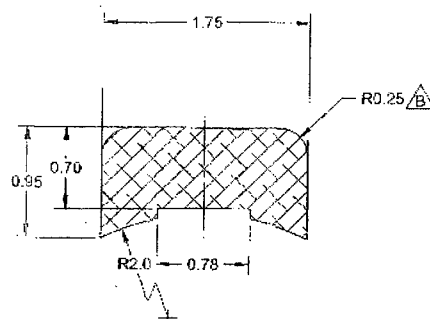
SECTION B-B CS-1
SCALE 2X



SECTION C-C CS-1
SCALE 2X



SECTION D-D CS-1
SCALE 2X



SECTION E-E CS-1
SCALE 2X

RELEASED
2011-11-16

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	147	DRAWING NO.	REV. B
MFG. APPR.	147	D3990	SHEET 2 OF 2
APPROVED	147	TITLE	SCALE
DE APPR.	147	CABLE GUARD	NTS
DATE	11.11.10	COPYRIGHT © 2009 BY DART AEROSPACE LTD	